

Date: Thursday, 6/15/2006 1:50:18 PM
User: Kim Johnston

Process Sheet

SLIP 1

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27579
Estimate Number : 10256
P.O. Number : NIA
This Issue : 6/15/2006 S.O. No. : NIA
Prsht Rev. : NC
First Issue : NIA Type : MACHINED PARTS
Previous Run : 26593
Written By : SEE COMMENT BELOW
Checked & Approved By : JF 06.06.15
Comment : Est D 90.05.18 Added inspection level 8, and removed P/O for powder coat EC

Drawing Name : MOUNTING LUG
Part Number : D22303
Drawing Number : D2230 REV F
Project Number : N/A
Drawing Revision : F
Material : NIA
Due Date : 7/5/2006 Qty: 200 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)
Lug Extrusion
D2423
Batch: B23779

J-F 06/06/19

204

2.0 BAND SAW BAND SAW



Comment: Band Saw
Cut D2423 extrusion to 0.82"
Batch: B23779

J-F 06/06/19

204

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2230-3
Check for crack while loading into the machine.

R/O 1521

C206120106

204

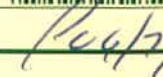
4.0 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Machine per drawing D2230 Rev.F

Receive + Inspect for transit damage



100

5.0 SECOND CHECK



Comment: SECOND CHECK

2607.10

100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:50:18 PM
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Drawing Name: MOUNTING LUG

Job Number: 27579

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



N/A

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAP 06:07:10

8.0

QC3

INSPECT WORK TO CURRENT STEP



E

Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06/07/10

(100)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

PC 06/07/11 100

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 371

PC 06/07/11 100

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q 06/07/12

Job Completion



W 06/07/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

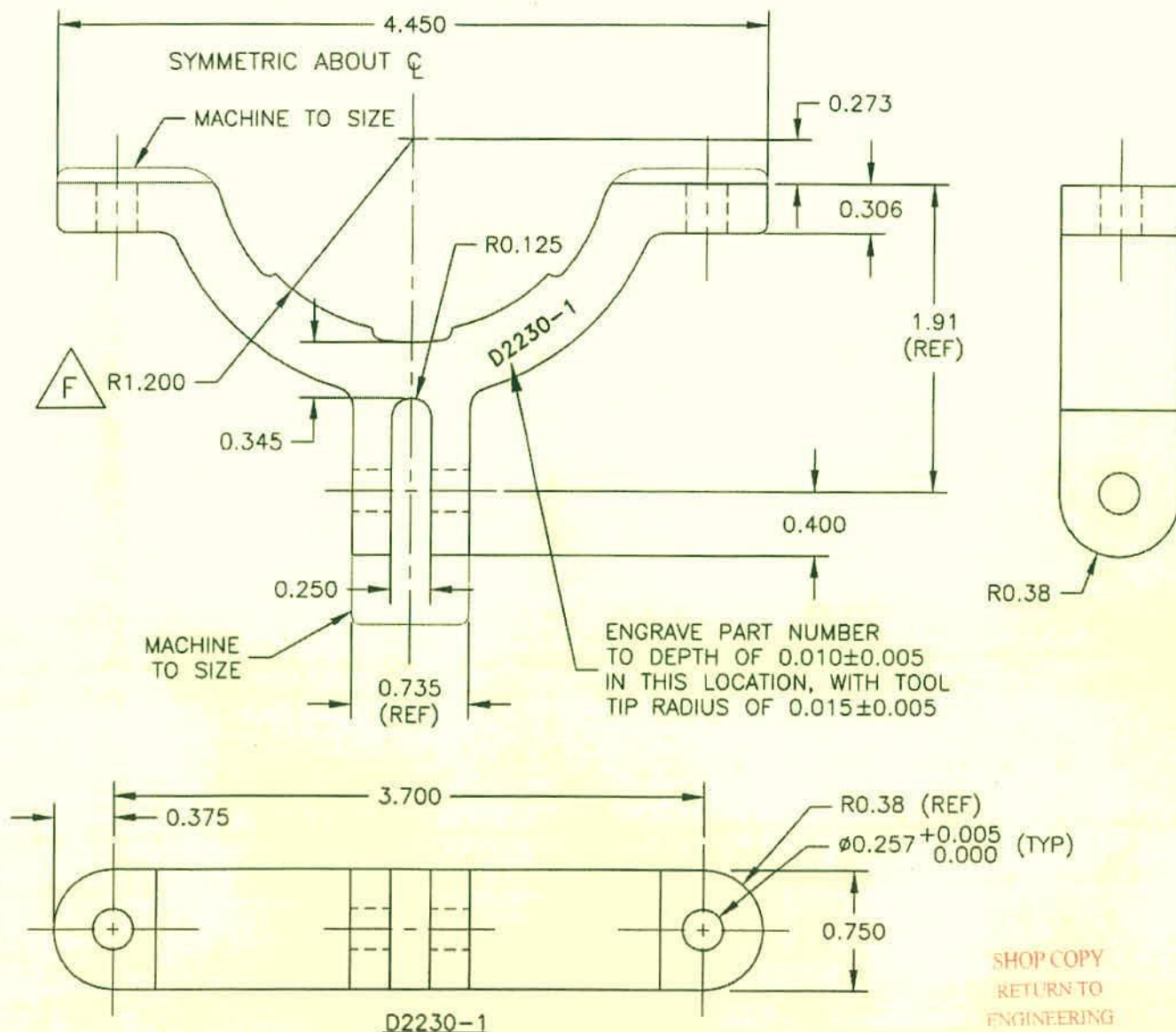
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>th</i>	APPROVED <i>th</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99-12-21 DS

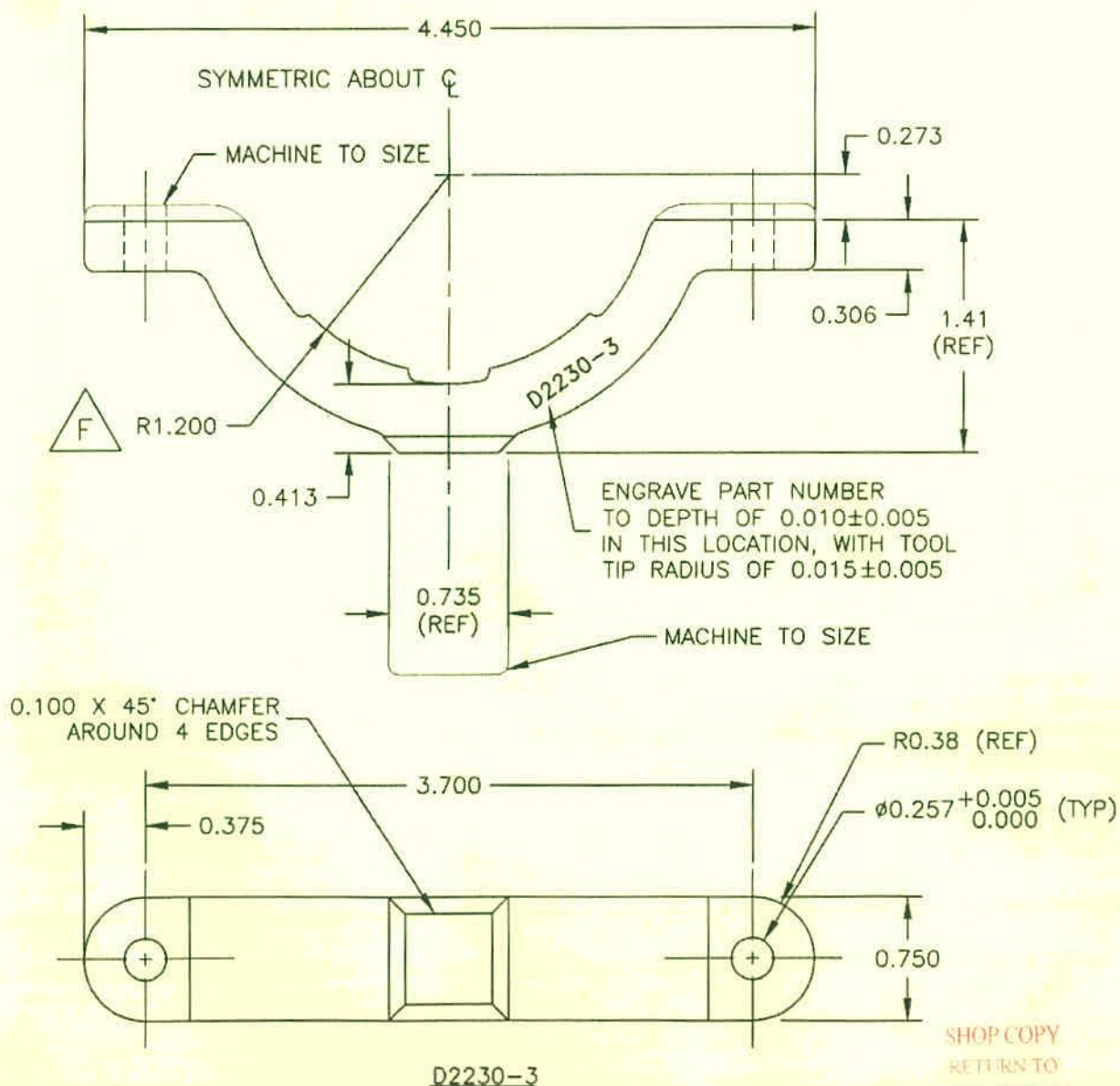
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27579



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
79.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITYPART NUMBERPART NAMEP.O. NUMBER

100

D 2230-3

Mounting Lug

1521

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, July 7, 2006

A handwritten signature in blue ink, followed by the date "06-07-10" written in a similar style.

